

Work Order ID 120302

Wednesday, June 04, 2014 3:01:24 PM

120302

Page 1

Item ID: D3405-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gh Lug

Stop

NS2

Start Date: 6/04/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJDate: 14-06-06

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	
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D3405	Rev B	
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100		0.00							DAS
-----	--	------	--	--	--	--	--	--	-----

100	FLOW WATER JET								23
--------------	----------------	--	--	--	--	--	--	--	----

Waterjet	Memo	0.00							9-89
----------	------	------	--	--	--	--	--	--	------

FLOW CNC Waterjet	1-Cut as per Dwg D3405								14-06-22
-------------------	------------------------	--	--	--	--	--	--	--	----------

	Dwg Rev: <u>B</u>								
--	-------------------	--	--	--	--	--	--	--	--

	Prog Rev: <u>B</u>								
--	--------------------	--	--	--	--	--	--	--	--

	2-Deburr if necessary								
--	-----------------------	--	--	--	--	--	--	--	--

110	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS
-----	---	------	--	--	--	--	--	--	-----

110									23
--------------	--	--	--	--	--	--	--	--	----

QC	Memo	0.00							9-89
----	------	------	--	--	--	--	--	--	------

Quality Control									14-06-22
-----------------	--	--	--	--	--	--	--	--	----------

120	QC8- Inspect parts - second check	0.00	<i>BB</i>	<i>DAS</i>					
-----	-----------------------------------	------	-----------	------------	--	--	--	--	--

120			<i>14-06-23</i>	<i>27</i>					
--------------	--	--	-----------------	-----------	--	--	--	--	--

QC	Memo	0.00	<i>9-89</i>						
----	------	------	-------------	--	--	--	--	--	--

Quality Control									
-----------------	--	--	--	--	--	--	--	--	--

(13)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS									
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Machining	Thermoforming	Large Fab	Crosstube	Small Fab	Finishing	Water Jet	Engineering	
NCR No. _____	Suspected Unapproved									Composite	Prod. Eng. Coor.	Rec/Store/Packaging	Quality
										Supplier		Other	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
	Bending		Bend		Folio/Program			Outside Dimensions		Pressure/Forced	
	Centre Not Concentric		BOM/Route		Grain			Over/Under tolerance		Set-up	
	Cracks		Broken/Damage/Defect		Hardware			Part Incorrect		Temperature/Cure	
	Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified			Part Lost/Missing		Weld	
	Cuffs		Contamination		Instructions Incomplete/Unclear			Part Moved		Wrong Stock Pulled	
	Crushing		Countersink		Misaligned/off center			Positioned Wrong			
	Heat Treat		Cut Too Short		Mislabeled			Power Loss/Surge		Other	
	Inspection Strip in Tube		Drawing		Misread						
	Marks/Chatter		Drill Holes		Off-set						
	Turning Sequence		Finish		Out of Calibration						
	Wave/Twist in Tube		Fit/Function		Out of Sequence						

Work Order ID 120302

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120302

Page 2

Item ID: D3405-043

Accept

Revision ID:

Item Name: Gh Lug

Start Date: 6/04/14 Start Qty: 8.00

8

Required Date: 6/04/14 Req'd Qty: 8.00

8***N900040100***

Setup

Start

NS1

Stop

NS2

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Brake NC

NC BRAKE

0.00

DAS
30
9.89

13

74/07/02

Brake NC

Memo

0.00

1-Deburr
2-Form using DT8204 as per Dwg D3405
3- use DT9681 to check if correct forming

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS
27
9.89
14/7/13

13

150

150

Large Fab

Weld per dwg A/R S.S. rod Batch: 1126048

0.00

Large Fab

Memo

0.00

Weld as per Dwg D3405 use DT8484
Identify as D3405-043

13

14-09-08

PBC

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS Skid-tube <input type="checkbox"/> Crosstube <input type="checkbox"/> Machining <input type="checkbox"/> Small Fab <input type="checkbox"/> Thermoforming <input type="checkbox"/> Finishing <input type="checkbox"/> Large Fab <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence					
						<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other					

Work Order ID 120302***120302***

Wednesday, June 04, 2014 3:01:24 PM

Page 3

Item ID: D3405-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gh Lug

Stop

NS2

Start Date: 6/04/14 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/04/14 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
Description

160

QC9- Inspect visual per QSI004- Fusion Welds

160

QC

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

DAS

50

1214-9-9

9-89

170

QC5- Inspect part completeness to step on W/O

0.00

DAS

38

9-89

170

QC

Quality Control

0.00

12

14-9-10

9-89

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Powder Coating

Memo

0.00

START TIME:

8:10

OVEN TEMPERATURE:

740

FINISH TIME:

8:401314-9-12

DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>			Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
				Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
Bending		Bend <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>						
Centre Not Concentric		BOM/Route <input type="checkbox"/>	Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>						
Cracks		Broken/Damage/Defect <input type="checkbox"/>	Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>						
Crimp/Kink/Ripple/Wave		Burrs <input type="checkbox"/>	Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>						
Cuffs		Contamination <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>						
Crushing		Countersink <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>							
Heat Treat		Cut Too Short <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>						
Inspection Strip in Tube		Drawing <input type="checkbox"/>	Misread <input type="checkbox"/>								
Marks/Chatter		Drill Holes <input type="checkbox"/>	Off-set <input type="checkbox"/>								
Turning Sequence		Finish <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>								
Wave/Twist in Tube		Fit/Function <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>								

Work Order ID 120302

Wednesday, June 04, 2014 3:01:24 PM

120302

Page 4

Item ID: D3405-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Gh Lug

Stop

NS2

Start Date: 6/04/14

Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Quality Control

13

8

20

4/09/15

200

Identify as per dwg & Stock Location:

81529

0.00

200

Packaging

Packaging

Memo

0.00

13x

14-9-15

DAS
26
9-89

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Quality Control

Memo

0.00

14/9/16 JJ

MM 4-9-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>			Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
				Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General																	
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube		<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function										<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/ Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled		<input type="checkbox"/> Other	

Picklist Print

Wednesday, June 04, 2014 3:01:24 PM

Page 1

Work Order ID: 120302

120302
D3405-043

Parent Item: D3405-043

Parent Item Name: Gh Lug

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A05.09.01 New issue KJ/JLM

IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3404-1		Manufactured	No			100	Each	70.0000	1	8			

D3404-1

GHW/ Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA001	70	
110801 14357	30	
113798	40	

**

14-09-08

1BC

M304S11GA

Purchased

No

M304S11GA
304/316 0.125 Sheet

150 sf 142.0000 0.154

**

DAS

23

9-69

140622

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	142	
122521	30	
M128254	112	

128254

DQA: _____ Date: _____



QA Closed: _____ Date: _____

Work Order update only

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____		Use-as-is <input type="checkbox"/>	Suspected Unapproved <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design										
Doc/Data										
Equip/Tooling										
Handling/Pre										
Material										
Operator										
Offset/Setup										
Process										
Supplier										
Training										
Transport										
Unapproved										
FAULT CATEGORY										
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence					

DART AEROSPACE LTD	Work Order:	120302
Description: GHW Bracket	Part Number:	D3405-3
Inspection Dwg: D3405 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article Prototype

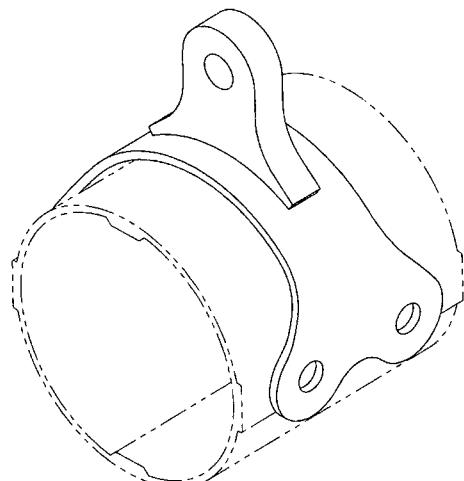
-PAS

Measured by:	23 9-89	Audited by:	SB 27 9-89	Prototype Approval:	N/A
Date:	14-06-22	Date:	14/6/23	Date:	N/A

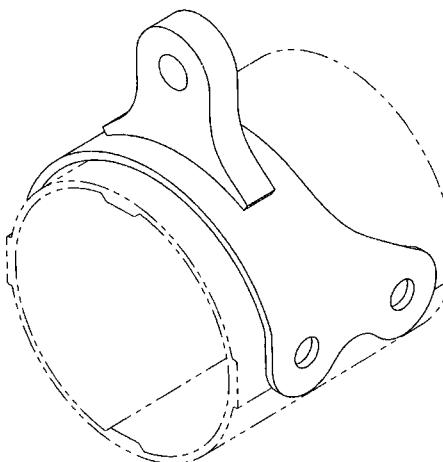
Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue P/O D3405-043	KJ/JLM	
B	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 120302 MCL

1406-06

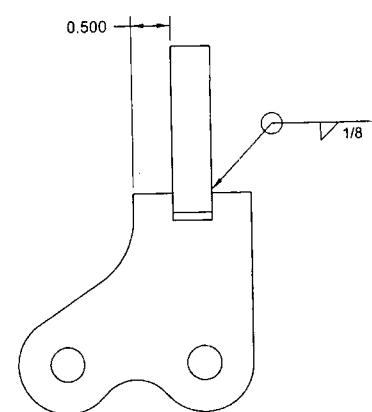
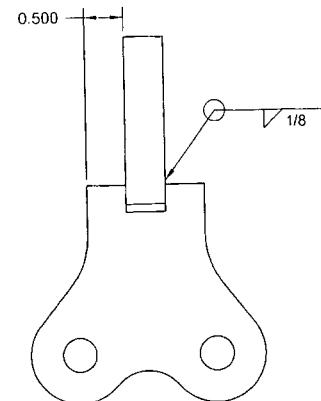
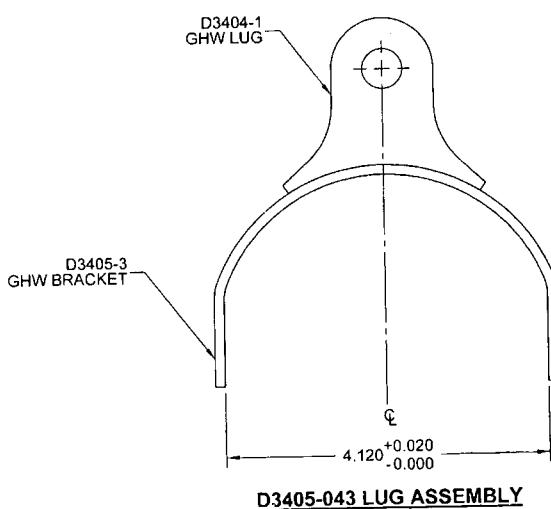
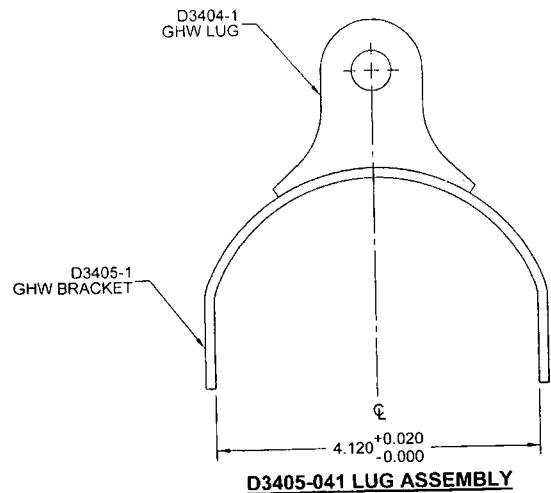
RELEASED
01/21/18 MCL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER DIMENSIONS FOR A - 8 - 3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A8 4.120 DIM WAS 4.100.			AJS	08.09.19
A	NEW ISSUE			PH	05.03.08
REV.	DESCRIPTION			BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	AJS	DRAWING NO. REV. B D3405 SHEET 1 OF 4			
CHECKED		MFG. APPR. APPROVED DATE 08.09.19			
MFG. APPR.		TITLE NTS GHW LUG ASSEMBLY			
APPROVED		SCALE			
DE APPR.		NTS			
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 1 7 6 1 5 4 1 3 1 2 1 1

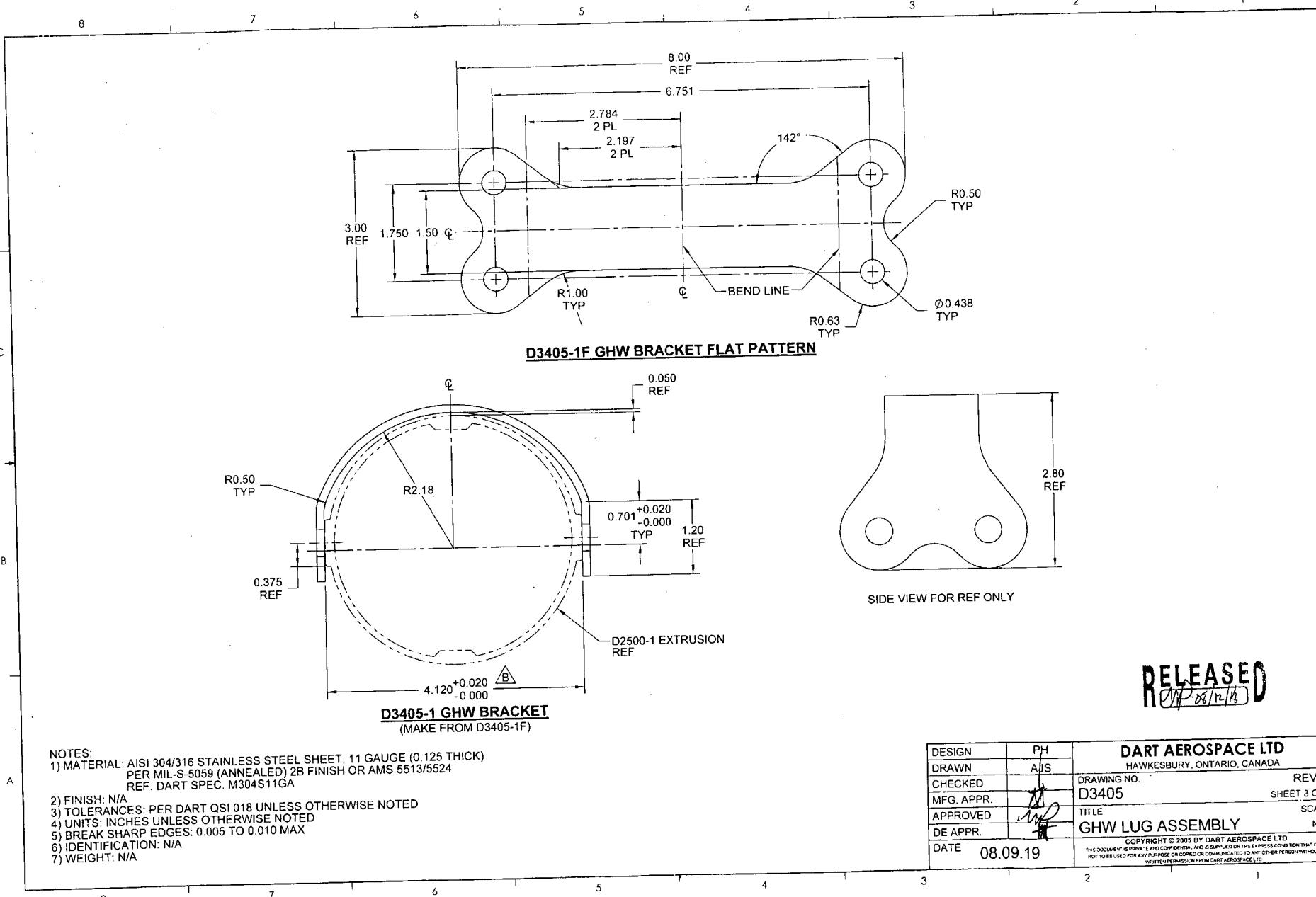


RELEASED
06/12/18 NM

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		DRAWING NO	
APPROVED		D3405	
DE APPR.		SHEET 2 OF 4	
DATE	08.09.19	TITLE	
		SCALE	
		GHW LUG ASSEMBLY	
		NTS	

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DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. B	
MFG. APPR.		DRAWING NO.	
APPROVED		D3405	
DE APPR.		SHEET 3 OF 4	
DATE 08.09.19		TITLE	SCALE
		GHW LUG ASSEMBLY	
NTS			

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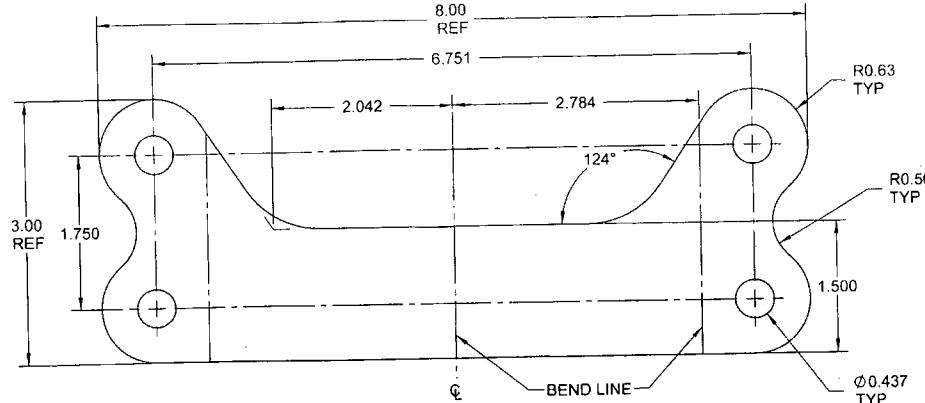
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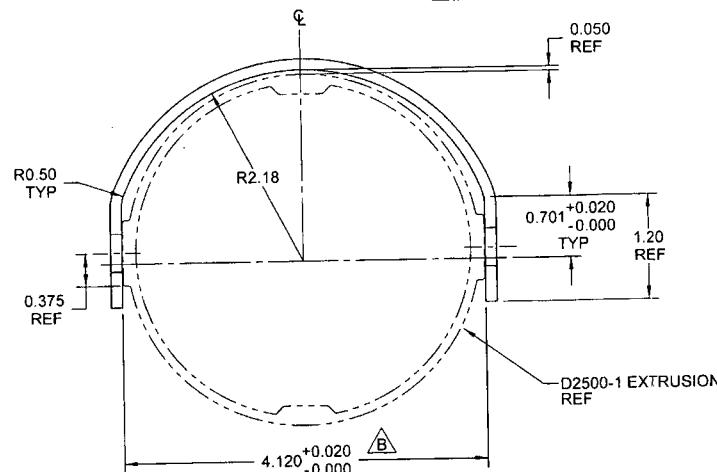
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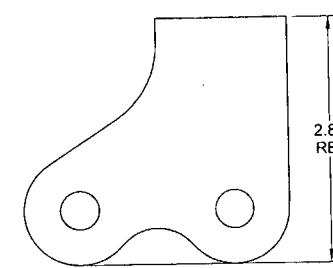


D3405-3F GHW BRACKET FLAT PATTERN

D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A



SIDE VIEW FOR REF ONLY

RELEASED
08/12/19

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